

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023507**Date Inspected:** 20-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|-----|----|-----|----------------------------------|-----|----|-----|
| CWI Name: | Mr. | | | CWI Present: | Yes | No | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |

Bridge No: 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Bay 19 / Suspender Bracket

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SA6031-098. The welder is identified as 058792. Quality Control (QC) is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with WPS- B-T-2133-ESAB. See attached photograph Pic_001.

Bay 19 / Suspender Bracket

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SA6029-131. The welder is identified as 062749. Quality Control (QC) is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with WPS- B-T-2133-ESAB.

Bay 16 / X3744B

This QA Inspector observed the following work in progress:

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Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # X3744B-15-001, as per B-WR# 20775. The welder is identified as 053753. Quality Control (QC) is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with WPS- 345-SMAW-2G(2F)-FCM-Repair.

Bay 16 / X3744B

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of repair weld # X3744B-15-001, as per B-WR# 20775. The welder is identified as 062092. Quality Control (QC) is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with WPS- 345-SMAW-1G(1F)-FCM-Repair.

Bay 14 / OBG Segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3019B-009, as per B-CWR# 2924. The welder is identified as 044772. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS- 345-SMAW-4G(4F)-FCM-Repair.

Bay 14 / OBG Segment 14E

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3019E0-185. The welder is identified as 051356. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS- B-T-2133-ESAB.

Bay 14 / OBG Segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of weld # SEG3019*-001. The welder is identified as 058102. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS- 2211-B-U2-FCM-1.



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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Gade,Ramesh | Quality Assurance Inspector |
| Reviewed By: | McClendon,Timothy | QA Reviewer |
